

Date: Thursday, 1/25/2007 10:21:28 AM
 User: Kim Johnston

Process Sheet

| | | | | | | |
|-----------------------|---|--|------------------|------------------------------|--|--|
| Customer | : CU-DAR001 Dart Helicopters Services | | Drawing Name | : SADDLE SPACER | | |
| Job Number | : 30451 | | Part Number | : D2934 | | |
| Estimate Number | : 11062 | | Drawing Number | : D2934 REV B | | |
| P.O. Number | : N/A | | Project Number | : N/A | | |
| This Issue | : 1/25/2007 S.O. No. : N/A | | Drawing Revision | : B | | |
| Prsh Rev. | : NC | | Material | : N/A | | |
| First Issue | : N/A | | Due Date | : 2/15/2007 Qty: 50 Um: Each | | |
| Previous Run | : 29345 | | | | | |
| Written By | : <u>W</u> | | | | | |
| Checked & Approved By | : <u>KY</u> 07.01.25 | | | | | |
| Comment | : Est A 00.06.06 New Issue EC Est Rev:B Now 6061-T6 06-06-23 JLM | | | | | |

Additional Product

Job Number:



| Seq. #: | Machine Or Operation: | Description : |
|---|-----------------------|--|
| 1.0 | M6061T6S080 | 6061-T6 .080 Sheet |
| | | |
| Comment: Qty.: 0.0334 sf(s)/Unit Total : 1.6695 sf(s) Material: 6061-T6 0.080" Thick Batch <u>4103032</u> | | |
| 2.0 | WATER JET | FLOW WATER JET |
| | | |
| Comment: FLOW WATER JET 1-Cut as per Dwg D2934 Dwg Rev: <u>B</u> Prog Rev: <u>B</u> | | |
| | | |
| 2-Deburr if necessary | | |
| 3.0 | QC2 | INSPECT PARTS AS THEY COME OFF MACHINE |
| | | |
| Comment: INSPECT PARTS AS THEY COME OFF MACHINE | | |
| 4.0 | QC8 | SECOND CHECK |
| | | |
| Comment: SECOND CHECK | | |
| 5.0 | HAND FINISHING1 | HAND FINISHING RESOURCE #1 |
| | | |
| Comment: HAND FINISHING RESOURCE #1 Acid etch and Alodine as per QSI 005 4.1 | | |
| | | |

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 07/02/13
QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Date: Thursday, 1/25/2007 10:21:29 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE SPACER

Job Number: 30451

Part Number: D2934

Job Number:



| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---|
| 6.0 | QC3 | INSPECT POWDER COAT/CHEMICAL CONVERSION |
| 7.0 | PACKAGING 1 | PACKAGING RESOURCE #1 |
| 8.0 | QC21 | FINAL INSPECTION/W/O RELEASE |

Job Completion



1/25/07

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
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NOTE: Date & initial all entries

| | | |
|--|---------------------|--------------------|
| DART AEROSPACE LTD | Work Order: | 30451 |
| Description: Saddle Spacer | Part Number: | D2934 |
| Inspection Dwg: D2934 Rev: B | | Page 1 of 1 |

FIRST ARTICLE INSPECTION CHECKLIST

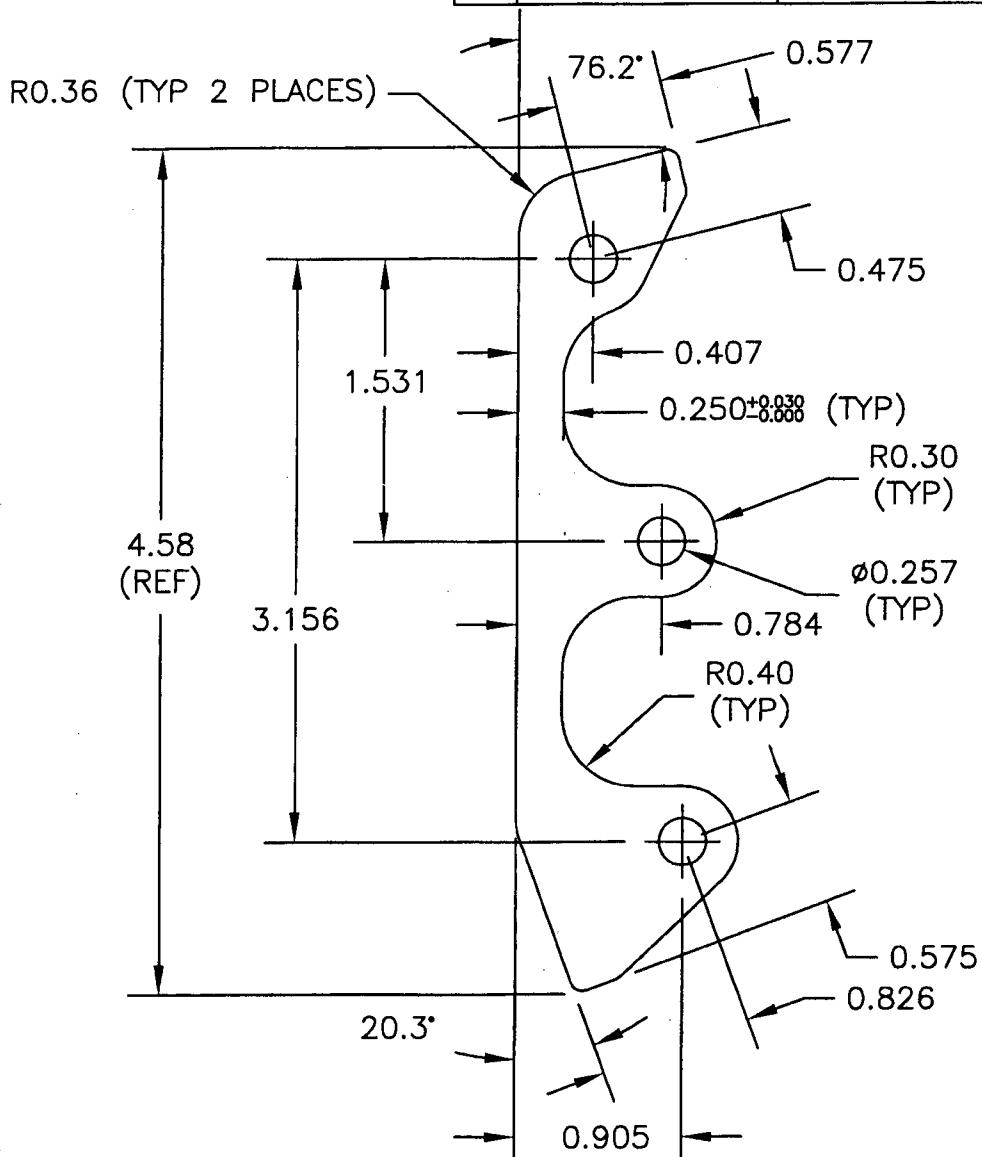
X First Article Prototype

| | | | | | |
|--------------|----------|-------------|----------|---------------------|-----|
| Measured by: | SAD | Audited by: | RG | Prototype Approval: | N/A |
| Date: | 07/01/28 | Date: | 07.01.28 | Date: | N/A |

| Rev | Date | Change | Revised by | Approved |
|-----|----------|------------------|------------|---|
| A | 04.08.12 | New Issue | KJ/JLM |  |
| B | 06.06.23 | Dwg Rev. changed | KJ/JLM |  |

DART

| | | | |
|----------------------|-----------------------|--|------------------------|
| DESIGN <i>PH</i> | DRAWN BY <i>CB</i> | DART AEROSPACE USA, INC. PORT HADLOCK, WA | |
| CHECKED <i>PH</i> | APPROVED <i>PH</i> | DRAWING NO. D2934 | REV. B SHEET 1 OF 1 |
| DATE 06.05.29 | | TITLE SADDLE SPACER | SCALE 1:1 |
| | | | |
| A | 99.11.02 | NEW ISSUE | |
| B | 06.05.29 | ADD 6061-T6 MATERIAL | |

**NOTES:**

- 1) MATERIAL: 6061-T6 (PER QQ-A-250/11 OR AMS 4025 OR AMS 4027) 0.080" THICK
(REF DART SPEC M6061T6S.080)
OR
5052-H32/H34 (PER QQ-A-250/8 OR AMS 4016) 0.080" THICK
(REF DART SPEC M5052H32S.080)
- 2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 5) ALL DIMENSIONS ARE IN INCHES

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